

**Work Order ID 59443**

Friday, June 04, 2010 10:29:01 AM



Page 1

Item ID: K10003

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, D205-634-011

Start Date: 6/4/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan: HDate: 10-6-04 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

IIN634,635

Rev F

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Create White labels only per PPP K10003

CHG 007

8/10/06/16PS 10-6-04

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

10-6-14 SP (8x)

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

8/12/06/1648

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID: K10003

Accept



Setup Start



Revision ID:

Item Name: Saddle, D205-634-011

Stop



Start Date: 6/4/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Packaging

Identify as per dwg & Stock Location: *PK*

0.00

*Rev J*

Memo

0.00

*10-6-16*

*(80) SP*

Packaging

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*10/06/17*  
*MF*  
*10-6-*  
*18*

W/O:		WORK ORDER CHANGES					
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Page 1

Work Order ID: 59443

Parent Item: K10003

Parent Item Name: Saddle, D205-634-011

Comments: IPP : I 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF  
 IPP : J 06-07-25 As per DSI 9344 JLM  
 IPP : K 06.11.17 Per K10003 Rev C KJ  
 IPP : L 07.01.12 Document Record for copying bluefile rmv KJ

Start Date: 6/4/2010

Required Date: 6/10/2010

Start Qty: 8.00

Required Qty: 8.00

AN4-51A



Bolt

Purchased No

110 Each

88.0000

8



64

442

M114941

10-6-25 SP

## Location

## Loc Qty

## Loc Code

ST361

88

112720

2

113121

1

114495

85

20

128

10-6-15 SP

AN4-6A



Bolt

Purchased No

110 Each

788.0000

16



## Location

## Loc Qty

## Loc Code

ST356

788

112933

96

113149

600

114523

2

114615

89

16067

1

54

74

132

10-6-15 SP (20)

AN4C47A



Bolt

Purchased No

110 Each

53.0000

4



## Location

## Loc Qty

## Loc Code

ST361

53

114653

53

35

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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 IPP : K 06.11.17 Per K10003 Rev C KJ  
 IPP : L 07.01.12 Document Record for copying bluefile rmv KJ

Start Date: 6/4/2010

Required Date: 6/10/2010

Start Qty: 8.00

Required Qty: 8.00

AN6-12A

Purchased

No

110

Each

118.0000

8

64



Bolt

Location

Loc Qty

Loc Code

ST342

118

112314

18

114523

100

AN960JD416

NAS1149D0463J

Purchased

No

110

Each

0.0000

32



Washer

AN960JD616

NAS1149D0663J

Purchased

No

110

Each

0.0000

8



Washer

D2570

Manufactured

No

110

Each

94.0000

24

192/100x



Bushing

Location

Loc Qty

Loc Code

ST018

94

58177

94

10-6-15 SP

107  
46  
256  
M114883  
M114576 10-6-14 SP

64  
M113524 M114340 10-6-14 SP

10-6-14 SP 92x

359592 92x  
10-6-15 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item Name: Saddle, D205-634-011

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Required Date: 6/10/2010

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 IPP : J 06-07-25 As per DSI 9344 JLM  
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 IPP : L 07.01.12 Document Record for copying bluefile rmv KJ

Start Qty: 8.00

Required Qty: 8.00

D2571

Manufactured No

110

Each

13.0000

1

Saddle, Fwd Out 205

Location

Loc Qty

Loc Code

ST425

8

43564

4

47564

4

ST433

5

58250

3

58667

2

D2572

Manufactured No

110

Each

7.0000

1

Saddle, Fwd In 205

Location

Loc Qty

Loc Code

ST425

4

43565

4

ST433

3

58668

3

D2573

Manufactured No

110

Each

9.0000

1

Saddle, Aft Out 205

Location

Loc Qty

Loc Code

ST425

8

43566

4

47566

4

ST434

1

58251

1

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Page 3

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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 IPP : J 06-07-25 As per DSI 9344 JLM  
 IPP : K 06.11.17 Per K10003 Rev C KJ  
 IPP : L 07.01.12 Document Record for copying bluefile rmv KJ

Start Date: 6/4/2010

Required Date: 6/10/2010

Start Qty: 8.00

Required Qty: 8.00

D2574



Saddle, Aft In 205

Manufactured No

110 Each

5.0000



1 8  
 359000 10-6 15

## Location

## Loc Qty

## Loc Code

ST425

4

43567

4

ST434

1

58252

1

D2747



Set Screw

Manufactured No

110 Each

81.0000



4 32  
 10-6-14

## Location

## Loc Qty

## Loc Code

ST023

81

39224

4

51921

77

D2876



Saddle Spacer

Manufactured No

110 Each

77.0000



2 16  
 10-6-14

## Location

## Loc Qty

## Loc Code

ST028

77

42364

30

51540

47

D2877



Saddle Spacer

Manufactured No

110 Each

72.0000



2 16  
 10-6-14 80

## Location

## Loc Qty

## Loc Code

ST028

72

51541

9

58531

63

7  
 7

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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 IPP : K 06.11.17 Per K10003 Rev C KJ  
 IPP : L 07.01.12 Document Record for copying bluefile rmv KJ

Start Date: 6/4/2010

Required Date: 6/10/2010

Start Qty: 8.00

Required Qty: 8.00

S +8	D3405-041	Manufactured	No	110	Each	8.0000	1	18	(52)
	Lug Assembly								10-6-14 sl B59232 sl
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
		ST474		8					
		57726		8					
S +8	D3405-043	Manufactured	No	110	Each	10.0000	1	8	(42)
	Lug Assembly								10-6-14 sl B59233 sl
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
		ST474		10					
		53888		1					
		57727		9					
S +8	D3407-041	Manufactured	No	110	Each	6.0000	1	18	(42)
	Tow Ring								10-6-15 sl B59208
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
		ST464		6					
		58209		6					
S +8	D3417-5	Manufactured	No	110	Each	83.0000	2	16	(84)
	Washer								10-6-14 sl
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
		ST056		83					
		52344		33					
		59250		50					

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 59443

Parent Item: K10003

Parent Item Name: Saddle, D205-634-011

Comments: IPP : I 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF  
 IPP : J 06-07-25 As per DSI 9344 JLM  
 IPP : K 06.11.17 Per K10003 Rev C KJ  
 IPP : L 07.01.12 Document Record for copying bluefile rmv KJ

Start Date: 6/4/2010

Required Date: 6/10/2010

Start Qty: 8.00

Required Qty: 8.00

D3456-1

Manufactured No

110 Each

123.0000

1

8



Washer

Location

Loc Qty

Loc Code

ST058

123

54692

123

D3533-1

Manufactured No

110 Each

107.0000

2

16



Set Screw

Location

Loc Qty

Loc Code

ST069

107

51602

107

MS21042L4

Purchased No

110 Each

4,043.000

24

192



Nut

Location

Loc Qty

Loc Code

ST139

2

111827

2

ST300

4041

113422

68

114523

965

114718

1000

114784

2000

9063

8

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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IPP : J 06-07-25 As per DSI 9344 JLM  
IPP : K 06.11.17 Per K10003 Rev C KJ  
IPP : L 07.01.12 Document Record for copying bluefile rmv KJ

Start Qty: 8.00

Required Qty: 8.00

MS21043-4

Purchased No

110

Each

1,595.000

5

40



Nut



10-6-14 SP

82

## Location

## Loc Qty

## Loc Code

FG	40	
104603	40	
ST301	1555	
112492	25	
113069	8	
114181	222	
114348	500	
114523	500	
114784	300	

27
B

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

## 5.0 PARTS LIST

Item	634 -011	634 -015	634 -041	634 -045	641 -011	Part Number	Description
	X					D205-634-011	SKIDTUBE INSTALLATION (STANDARD)
		X				D205-634-015	SKIDTUBE INSTALLATION (MODIFIED)
	1		X			D205-634-041	SKIDTUBE
		1		X		D205-634-045	SKIDTUBE
	1	1			X	D205-641-011	GROUND HANDLING KIT
1			1			D2580-041	205 SKIDTUBE ASSEMBLY (STANDARD)
1				1		D2580-045	205 SKIDTUBE ASSEMBLY (MODIFIED)
2A			16	16		D2594-1	* PLUG
2B			16	16		D2594-3	* O-RING
3			1	1		D2855	* AFT CAP
4			2	2		AN3-5A	* BOLT
5			2	2		AN960JD10L	* WASHER
6A			1	1		D3564-9	* WEARSHOE (REPLACES D2577-1)
6B			1	1		D3566-1	* GASKET
7A			1	1		D3564-11	* WEARSHOE (REPLACES D2577-3)
7B			1	1		D3566-1	* GASKET
8A			1	1		D3564-5	* WEARSHOE (REPLACES D2577-5)
8B			1	1		D3566-5	* GASKET
9A			1	1		D3564-13	* WEARSHOE
9B			1	1		D3566-13	* GASKET
10			50	50		AN3C4A	* BOLT (REPLACES AN3-4A)
11			50	50		AN960C10L	* WASHER (REPLACES AN960JD10L)
12			50	50		ALS4-1032-130	* INSERT
13			2	2		ALS4-1032-225	* INSERT
20	1	1				D2571	SADDLE, FWD OUTSIDE
21	1	1				D2572	SADDLE, FWD INSIDE
22	1	1				D2573	SADDLE, AFT OUTSIDE
23	1	1				D2574	SADDLE, AFT INSIDE
24	8	8				AN4-51A	BOLT
25	16	16				D2570	BUSHINGS
26	8	8				MS21042L4	NUT (OR MS21042-4)
27	8	8				AN6-12A	BOLT
28	8	8				AN960JD616	WASHER
29	16	16				AN4-6A	BOLT
30	32	32				AN960JD416	WASHER
31	16	16				MS21042L4	NUT (OR MS21042-4)
32	4	4				D2747	SET SCREW
33	2	2				D3533-1	SET SCREW
40	1	1				D3407-041	TOW RING (REPLACES D2968-041)
41	1	1				D3456-1	WASHER
43	1	1				MS21043-4	NUT
44	2	2				D3417-5	WASHER
50					1	D3405-041	LUG ASSEMBLY (REPLACES D2736-1)
51					1	D3405-043	LUG ASSEMBLY (REPLACES D2736-3)
52					4	AN4C47A	BOLT
53					8	D2570	BUSHING
54					4	MS21043-4	NUT (OR MS21042-4)
60	2	2				D2876	SADDLE SPACER
61	2	2				D2877	SADDLE SPACER

\*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: F

Date: 08.10.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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